

	NAME	DATE
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TECHNICAL BULLETIN – TB-212

TECHNICAL BULLETIN, PUSHBUTTON SEAL REPLACEMENT FOR S90/S100

TB-212

1.3

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TB-212

SHEET 1 of 6

PURPOSE:

THE PURPOSE OF THIS TECHNICAL BULLETIN IS TO PROVIDE NECESSARY INSTRUCTIONS TO THE CUSTOMER FOR PROPER INSTALLATION OF SERIES 90/100 PUSHBUTTONS INTO SWITCHES.

STEP BY STEP PROCEDURE for SERIES 90/100 PUSHBUTTON INSTALLATION:

1. WITHOUT STRETCHING THE SEAL, INSTALL THE PUSHBUTTON SEAL AROUND THE PUSHBUTTON, PUTTING THE SEAL AROUND THE FACE SIDE AND NOT THE ELECTRICAL SIDE (**FIGURE 1**). SLIDE SEAL DOWN INTO THE POSITION RIGHT BELOW THE FACE PLATE.

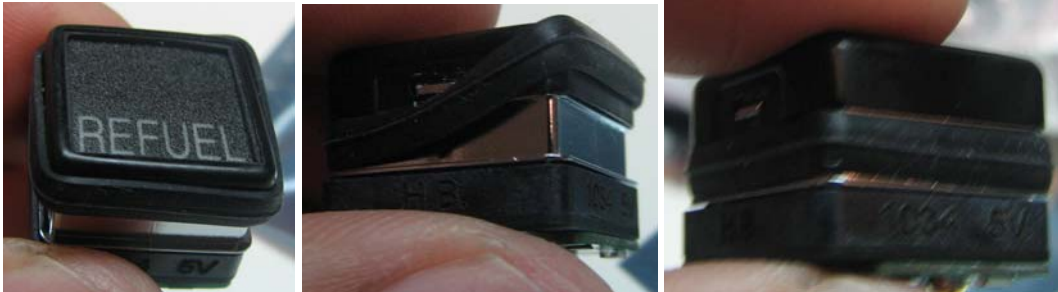


FIGURE 1 – PUTTING SEAL ON

- 1.5 PLACE A SMALL AMOUNT OF MAGNALUBE-G GREASE IN A WORKING TRAY. PLACE A Q-TIP IN MAGNALUBE-G GREASE AND SPREAD EVENLY BY SWIPING THE Q-TIP BACK AND FORTH IN TRAY. USE Q-TIP TO SPREAD A THIN FILM OF GREASE ALL AROUND THE INSIDE OF THE HOUSING AS SHOWN IN FIGURE 1.5. ENSURE GREASE IS COATED THIN AND EVENLY THROUGHOUT ALL FOUR INSIDE SURFACES.



FIGURE 1.5 – APPLY THIN FILM OF GREASE TO INSIDE OF HOUSING

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12522	TB-212	1.3	3

2. APPLY PRESSURE TO TOP AND THE SIDES OF THE SEAL AND PLACE PUSHBUTTON INTO HOUSING (**FIGURE 4A**). PUSH THE BUTTON IN SO IT IS ENGAGED BUT DO NOT FORCE IT ALL THE WAY IN (**FIGURE 4B**). LIGHT SQUEEZING OF THE SIDES OF THE SEAL WILL AID IN INSTALLATION. SOME OF THE SEAL MAY BE PROTRUDING OUT THE SIDES OF THE HOUSING.

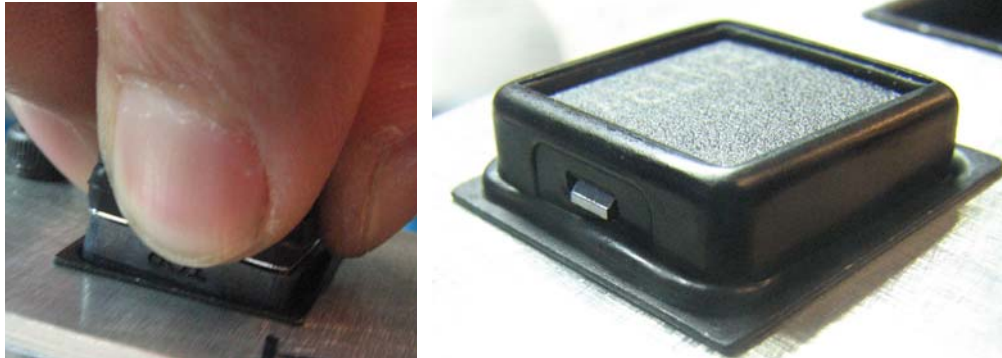


FIGURE 4A AND FIGURE 4B – ENGAGING PUSHBUTTON

3. USING A FLAT EDGED OBJECT THAT WILL NOT TEAR THE SEAL, WHEREVER THE SEAL IS PROTRUDING OUT, PUSH THE SEAL IN FROM OUTSIDE TO INSIDE BEGINNING ON ONE OF THE FLAT SIDES (**FIGURES 5A & 5B**). CONTINUE TO PUSH THE SEAL IN GOING ALONG EACH SIDE (**FIGURE 5C**). WHEN PROPERLY INSTALLED, NO PART OF THE SEAL SHOULD BE HANGING OUT (**FIGURE 5D**). SEE **FIGURES 5E** FOR EXAMPLES OF **UNACCEPTABLE** OBJECTS.



FIGURES 5A & 5B – PUSHING SEAL FROM OUTSIDE TO IN



FIGURE 5C – SEAL HALF WAY PUSHED IN

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TB-212

REV.
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4



FIGURE 5D – FINISHED PRODUCT



FIGURE 5E – UNACCEPTABLE OBJECTS TO PUSH SEAL WITH

4. AFTER SEAL HAS COMPLETELY BEEN PUSHED IN USING A FLAT EDGED OBJECT, PUSH THE BUTTON COMPLETELY INTO THE SWITCH (**FIGURE 6 - CORRECT**). STOP PUSHING THE BUTTON IF YOU NOTICE THE SEAL IS NOT PUSHING IN EASILY AND REPEAT STEP 5 (**FIGURE 6 – INCORRECT**). IT IS RECOMMENDED THAT THE PUSHBUTTON BE ACTUATING APPROXIMATELY 5 TIMES TO ENSURE THAT THE SEAL HAS PROPERLY SEATED ITSELF INTO THE HOUSING.

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12522	TB-212	1.3	5



FIGURE 6 – CORRECT

DO NOT PRESS PUSHBUTTON DOWN IF SEAL LOOKS LIKE THIS



FIGURE 6 – INCORRECT

5. REPEAT PROCESS EACH TIME A PUSHBUTTON NEEDS TO BE INSTALLED.

CAGE CODE	DRAWING NO.	REV.	SHT.
12522	TB-212	1.3	6